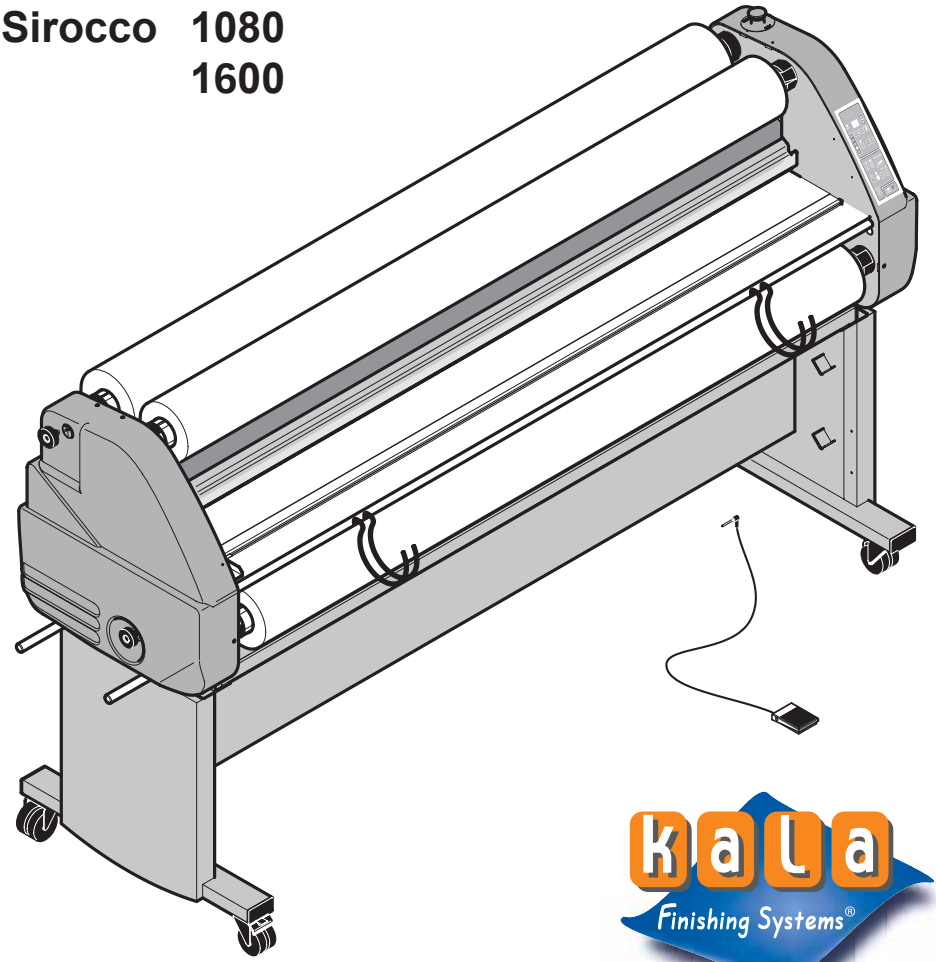
USER'S MANUAL

Sirocco 1080
1600



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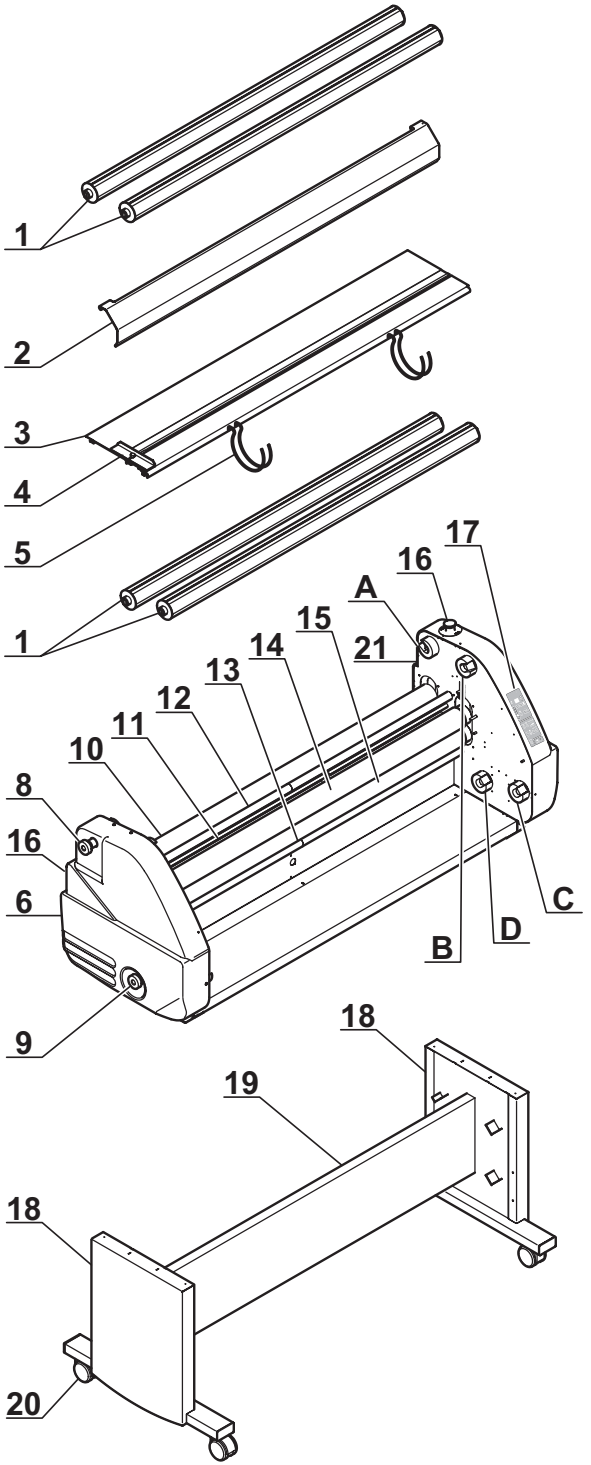
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Composants de la plastifieuse

Rep	Désignation
1	Axes autobloquants
2	Carter de protection plexiglas
3	Table de travail
4	Butée latérale
5	Paniers support document
6	Capot gauche
7	Capot droit
8	Poignée supérieure de réglage de la tension des films
9	Poignée inférieure de réglage de la tension des films
10	Rouleau laminateur supérieur
11	Rouleau laminateur inférieur
12	Barre de tension supérieure
13	Barre de tension inférieure
14	Rouleau chauffant supérieur
15	Rouleau chauffant inférieur
16	Bouton d'arrêt d'urgence
17	Panneau de commande
18	Côtés du stand
19	Cloison de stand
20	Roulettes
21	Interrupteur Marche / Arrêt

Parts list of the laminator

Item	Designation
1	Self-locking axles
2	Plexiglass safety cover
3	Working table
4	Lateral stop
5	Document support trays
6	Left-hand cover guard
7	Right-hand cover guard
8	Upper Film tension adjustment handles
9	Lower Film tension adjustment handles
10	Upper laminator roller
11	Lower laminator roller
12	Upper tension bar
13	Lower tension bar
14	Upper heating roller
15	Lower heating roller
16	Emergency stop button
17	Control panel
18	Sides of support unit
19	Support unit panel
20	Small wheels
21	On/Off switch

Componentes de la plastificadora

Ref	Designación
1	Ejes autoblocantes
2	Cárter de protección plexiglás
3	Mesa de trabajo
4	Tope laterale
5	Cesto soporte documento
6	Cubierta izquierda
7	Cubierta derecha
8	Puño superior de ajuste de la tensión de las peliculas
9	Puño inferior de ajuste de la tensión de las peliculas
10	Rodillos laminadores superior
11	Rodillos laminadores inferior
12	Barra de tensión superior
13	Barra de tensión inferior
14	Rodillos calentadores superior
15	Rodillos calentadores inferior
16	Botón de parada de emergencia
17	Cuadro de mandos
18	Lados del soporte
19	Tabique del soporte
20	Ruedecillas
21	Interruptor Marcha/Parada

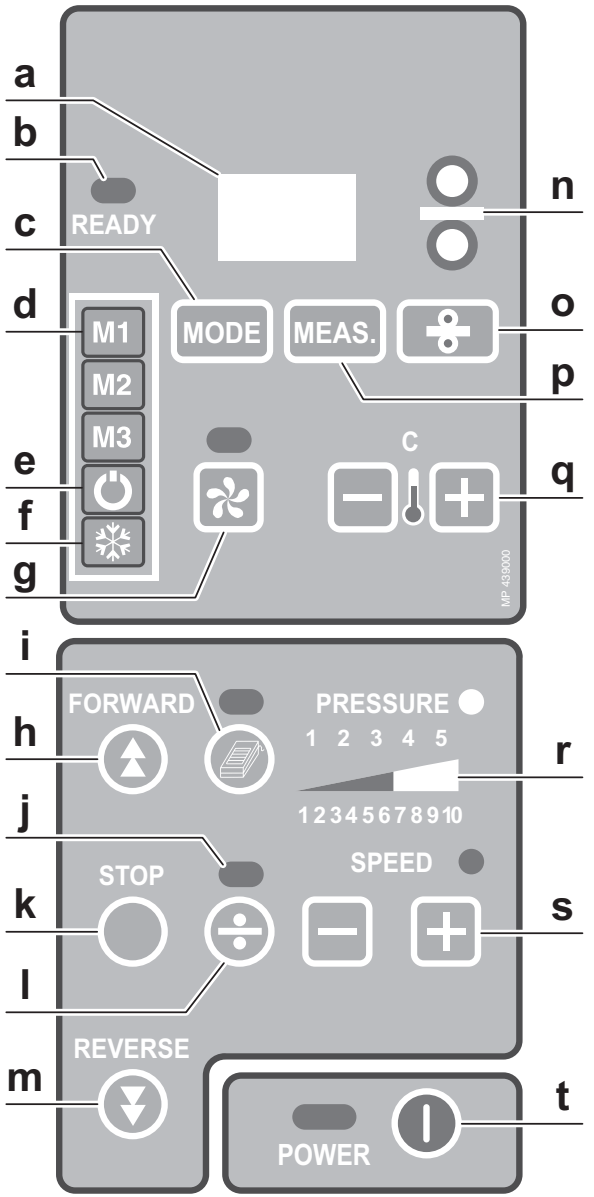
Bauteile des Laminators

Pos.	Bezeichnung
1	selbstblockierende Auf- bzw. Abwickelachsen
2	Schutzabdeckung aus PlexiglasPaniers support
3	Anlegetisch
4	Seitenanschlag
5	Dokumentenhalter
6	Abdeckung links
7	Abdeckung rechts
8	Einstellknopf obere Folienspannung
9	Einstellknopf untere Folienspannung
10	obere Laminatorwalze
11	untere Laminatorwalze
12	obere Spannleiste
13	untere Spannleiste
14	oberer Heizzylinder
15	unterer Heizzylinder
16	Notausschalter
17	Berührungsfeld-Steuerpult
18	Untergestell-Seitenteile
19	Untergestell-Mittelteil
20	Laufrollen
21	Ein-Ausschalter

Componenti della plastificatrice

Rif.	Descrizione
1	Assi autobloccanti
2	Carter di protezione plexiglas
3	Piano di alimentazione
4	Arresto laterale
5	Vassoi supporto documento
6	Calotta sinistra
7	Calotta destra
8	Manopola superiore di regolazione della tensione dei film
9	Manopola inferiore di regolazione della tensione dei film
10	Rullo laminatore superiore
11	Rullo laminatore inferiore
12	Barra di tensione superiore
13	Barra di tensione inferiore
14	Rullo riscaldante superiore
15	Rullo riscaldante inferiore
16	Pulsante di arresto d'emergenza
17	Pannello di controllo
18	Lati del supporto
19	Divisorio del supporto
20	Rotelle
21	Interruttore acceso/spento

SIROCCO 1080, 1600



Panneau de commande

Rep	Désignation
a	Affichage digital de la température.
b	Voyant Ready
c	Sélection des mémoires et du mode de plastification
d	Visualisation du programme actif
e	Mode veille (plastification à chaud)
f	Visualisation du mode plastification à froid
g	Mise en route des ventilateurs
h	Marche avant des rouleaux + montée du rouleau supérieur (S1080 / S1600)
i	Commande par pédale
j	Visualisation du mode "écartement des rouleaux"
k	Arrêt des moteurs
l	Sélection écartement des rouleaux
m	Marche arrière des rouleaux + descente du rouleau supérieur (S1080 / S1600)
n	Voyant rouge allumé visualise la mise en chauffe des rouleaux
o	Sélection des rouleaux chauffants
p	Visualisation de la température réelle des rouleaux
q	Réglage de la température
r	Affichage digital de la pression ou de la vitesse des rouleaux (S1080 / S1600)
s	Réglage de la vitesse (S1080 / S1600)
t	Mise en veille

Control panel

Item	Designation
a	Digital temperature display
b	Ready light
c	Selection of the memories and of the mode of lamination
d	Visualisation of the active program
e	Stand-by position (hot lamination)
f	Visualisation of the mode cold lamination
g	Starting of the ventilators
h	Forward motion of the rollers + rise of the upper roller (S1080 / S1600)
i	Using pedal switch
j	Visualisation of the mode “spacing of the rollers”
k	Motor stop
l	Selection spacing of the rollers
m	Reverse motion of the rollers + descent of the upper roller (S1080 / S1600)
n	Red light on indicates rollers are heating
o	Control of heating cylinder(s)
p	Visualisation of the real temperature of the rollers
q	Temperature adjustment
r	Roller pressure and speed digital display (S1080 / S1600)
s	Speed adjustment (S1080 / S1600)
t	Stand-by switch

Cuadros de mandos

Ref	Designación
a	Visualización de la temperatura
b	Señal READY
c	Selección de las memorias y del modo de plastificación
d	Visualización programa activo
e	Modo stand-by (laminación en caliente)
f	Visualización del modo de laminación en frío
g	Conexión de los ventiladores
h	Marcha delantera de los rodillos y descenso del rodillo superior (S1080 / S1600)
i	Control mediante pedal
j	Visualización del modo “distancia de los rollos”
k	Parada de los motores
l	Selección distancia de los rodillos
m	Marcha atrás de los rodillos y descenso del rodillo superior (S1080 / S1600)
n	Piloto rojo enciendido visualiza la puesta en calentamiento de los rodillos
o	Visualización de la temperatura real de los rodillos
p	Ajuste de la temperatura
q	Visualización digital de la presión o de la velocidad de los rodillos (S1080 / S1600)
r	Ajuste de la velocidad (S1080 / S1600)
s	Puesta en vela
t	

Berührungsfeld-Steuerpult

Pos.	Bezeichnung
a	digitale Temperaturanzeige
b	Anzeige "Betriebsbereit"
c	Auswahl Speicher und Betriebsart
d	Anzeige aktives Programm
e	Stand by (Heißlaminieren)
f	Betriebsanzeige "Kaltlaminieren"
g	Kühlventilatoren einschalten
h	Walzen vorwärts laufen lassen und obere Walze hochfahren (S1080/ S1600)
i	Fußschalter
j	Betriebsanzeige "Walzen öffnen"
k	Motor abschalten
l	Auswahl Walzenöffnung
m	Walzen rückwärts laufen lassen und obere Walze senken (S1080 / S1600)
n	Einstellungsanzeige "Heizzylinder eingeschaltet", die rote Diode leuchtet
o	Auswahl der Heizzylinder
p	Anzeige der echten Walzentemperatur
q	Temperatureinstellung
r	digitale Druckanzeige oder Walzengeschwindigkeitsanzeige (S1080/ S1600)
s	Geschwindigkeitseinstellung (S1080/S1600)
t	Hauptschalter

Pannello di controllo

Rif.	Descrizione
a	Display digitale della temperatura
b	Spia ready
c	Selezione delle memorie e della modalità di plastificazione
d	Visualizzazione del programma attivo
e	Modalità standby (plastificazione a caldo)
f	Visualizzazione della modalità plastificazione a freddo
g	Avviamento dei ventilatori
h	Marcia in avanti dei rulli + salita del rullo superiore (S1080 / S1600)
i	Comando tramite pedale
j	Visualizzazione della modalità "distanza dei rulli"
k	Arresto dei motori
l	Selezione distanza dei rulli
m	Marcia indietro dei rulli + discesa del rullo superiore (S1080 / S1600)
n	Spia rossa accesa visualizza il riscaldamento dei rulli
o	Selezione dei rulli riscaldanti
p	Visualizzazione della temperatura reale dei rulli
q	Regolazione della temperatura
r	Display digitale della pressione o della velocità dei rulli (S1080 / S1600)
s	Regolazione della velocità (S1080/ S1600)
t	Messa in standby

Déclaration de conformité

KALA S.A.S.
Parc de l'Ecotay
35 410 NOUVOITOU
FRANCE.
Déclare que le produit suivant :
Modèle : **SIROCCO** est conforme aux exigences suivantes

Voltage 220-240V :
- Directive machines : (98/37 CEE) incluant :
- Directive basse tension (73/23 CEE) selon la norme **EN 60204 - 1** (1997)
- Directive Compatibilité Electromagnétique (89/336 CEE) selon la norme **EN 55014**, Edition 1993 et **EN 55014-2** Edition 1997.

Toujours à la recherche du progrès, nous nous réservons le droit de modifier sans préavis les modèles ainsi que les équipements et leurs caractéristiques techniques.

Declaration of conformity

KALA S.A.S.
Parc de l'Ecotay
35 410 NOUVOITOU
FRANCE.
Declares that the following product:
SIROCCO Model conforms to the following requirements

Voltage 220-240V:
- Machine Directive : (98/37 EEC) :
- Low voltage Directive (73/23 EEC) according to the **EN 60204 – 1** (1997)
- Electromagnetic compatibility Directive (89/336 EEC) according to the **EN 55014**, Edition 1993 and **EN 55014-2** Edition 1997.

Always seeking to make progress, we reserve ourselves the right to change without notice the models as well as the equipment and their technical features.

Konformitätsbestätigung

KALA S.A.S.
Parc de l'Ecotay
35 410 NOUVOITOU
FRANCE.
bestätigt, daß folgendes Produkt:
Modell **SIROCCO** folgende Forderungen erfüllt

Spannung 220-240V:
- Maschinenrichtlinie: (98/37 CEE) :
- Niederspannungs-Richtlinie (73/23 CEE) gemäss EN 60204 – 1 (1997)
- Richtlinie bezüglich der elektromagnetischen Verträglichkeit (89/336 CEE) gemäss EN 55014, Ausgabe 1993 und EN 55014-2 Ausgabe 1997

Sempre alla ricerca di innovazioni, ci riserviamo il diritto di modificare senza preavviso i modelli, le apparecchiature e le loro caratteristiche tecniche.

Dichiarazione di conformità

KALA S.A.S.
Parc de l'Ecotay
35 410 NOUVOITOU
FRANCE.
Dichiara che il seguente prodotto:
Modello: **SIROCCO** è conforme alle seguenti direttive

Tensione 220-240V:
- Direttiva macchina: (98/37 CEE) :
- Direttiva bassa tensione (73/23 CEE) conformemente alla normativa **EN 60204 - 1** (1997)
- Direttiva Compatibilità Elettromagnetica (89/336 CEE) conformemente alla normativa **EN 55014**, Edizione 1993 e **EN 55014-2** Edizione 1997

Sempre alla ricerca di innovazioni, ci riserviamo il diritto di modificare senza preavviso i modelli, le apparecchiature e le loro caratteristiche tecniche.

Declaración de conformidad

KALA S.A.S.
Parc de l'Ecotay
35 410 NOUVOITOU
FRANCE.
Declara que el producto siguiente:
Máquina modelo **SIROCCO** está en conformidad con las exigencias siguientes

Voltaje 220 - 240V:
- Directiva máquina: (98/37 CEE) :
- Directiva baja tensión (73/23 CEE) según la norma **EN 60204 - 1** (1997)
- Directiva Compatibilidad Electromagnética (89/336 CEE) según las normas **EN 55014**, Edición 1993 y **EN 55014-2**

Siempre en pos del mayor progreso, nos reservamos el derecho de modificar sin aviso previo las características y los equipos técnicos de los modelos.

Garantie

Votre Sirocco est garantie contre tous défauts de matériaux et de fabrication pendant une période d'un an après la date d'achat. En cas de défauts de matériaux ou de fabrication, la société ayant vendu l'appareil réparera celui-ci dans ses ateliers ou le retournera au fabricant. Il n'existe aucune garantie autre que celle qui vient d'être mentionnée ci-dessus. Cette garantie ne couvre pas les dommages particuliers ou résultants de causes indirectes, qu'ils soient ou non prévisibles. La garantie ne couvre pas les mauvaises utilisations de la machine.

Réglementation de retour :
Si votre Sirocco ne fonctionne pas bien, relisez d'abord les instructions. Si le fonctionnement défectueux ne peut-être corrigé, demandez conseil à votre fournisseur. Assurez-vous que le numéro de série et la date d'achat de votre appareil soient à portée de main. Si vous devez retourner la machine au fournisseur, elle devra être dans son emballage d'origine. Les dommages de transport résultants d'un emballage défectueux ne sont pas couverts selon les termes de cette garantie.

Warranty

Your Sirocco is guaranteed against all defects of materials and manufacturing for a period of one year from the date of purchase. In the event of defects of materials or manufacturing, the company which sold the instrument will repair it or it will be returned to the manufacturer. There is no warranty other than the one mentioned above. This warranty does not cover individual damage or damage resulting from indirect causes, whether foreseeable or not. The warranty does not cover incorrect use of the machine.

Return regulations:
If your Sirocco does not fwork correctly, firstly read the instructions again. If the defective operation cannot be corrected, consult your supplier. Make sure that the series number and the date of purchase of your machine are to hand, if you have to return the machine to the supplier. Damage during transport resulting from defective packaging is not covered under the terms of this guarantee.

Garantie

Ihre Sirocco Maschine weist vom Kaufdatum ab eine einjährige Garantie gegen jeglichen Material- und Herstellungsfehler auf. Falls Material- oder Herstellungsfehler auftreten sollten, so wird die Firma, die das Gerät verkauft hat, dieses in ihren eigenen Werkstätten reparieren oder an den Hersteller zurücksenden. Es gibt keinerlei andere Garantie als die obengenannte. Diese Garantie deckt nicht die besonderen Schäden oder die Schäden, die indirekt verursacht worden sind, ob diese vorhersehbar sind oder nicht. Die Garantie deckt nicht die falschen Anwendungen der Maschine.

Rücksendungs-Regelung:
Falls Ihre Sirocco nicht richtig funktionieren sollte, lesen Sie zuerst noch einmal die Anweisungen durch. Wenn das Problem nicht behoben werden kann, fragen Sie Ihren Händler um Rat. Stellen Sie sicher, daß die Seriennummer und das Einkaufsdatum Ihres Geräts griffbereit sind, falls Sie die Maschine zum Händler zurücksenden müssen. Die Transportschäden, die von einer fehlerhaften Verpackung herrühren, stellen keinen Garantiefall dar.

Garanzia

La garanzia della vostra Sirocco copre tutti i difetti di materiale e di fabbricazione per un anno a partire dalla data di acquisto. In caso di difetti di materiale o di fabbricazione, la società che ha venduto la macchina provvederà a ripararla presso il proprio servizio assistenza o a restituirla al fabbricante. Non esiste altra garanzia oltre a quella sopra citata. Tale garanzia non copre i danni speciali o dovuti a cause indirette, indipendentemente dal fatto che siano o meno prevedibili. La garanzia non copre i danni legati ad un cattivo uso della macchina.

Disposizioni per la restituzione:
Se la vostra Sirocco non funziona correttamente, si consiglia innanzitutto di rileggere il libretto d'istruzioni. Qualora non fosse possibile correggere il funzionamento difettoso, chiedete consiglio al vostro fornitore. Accertatevi di avere sotto mano il numero di serie della macchina e la data di acquisto nel caso in cui dobbiate restituire la macchina al fornitore. I danni da trasporto dovuti ad un imballaggio difettoso non sono coperti ai sensi delle condizioni della presente garanzia.

Garantía

La máquina Sirocco está garantizada contra todos los defectos de material y fabricación durante un periodo de un año después de la fecha de compra. En caso de defectos de material o fabricación, la sociedad que ha vendido el aparato lo reparará en sus talleres o lo devolverá al fabricante, no habiendo ninguna otra garantía. Estas garantía no cubre los daños particulares o que resulten de causas indirectas, previsibles o imprevisibles. La garantía no cubre la mala utilización de la máquina.

Reglamentación de devolución:
Si su máquina Sirocco no funciona bien, lea de nuevo las instrucciones. Si el funcionamiento defectuoso no puede corregirse con éstas, solicite consejo a su proveedor. Cerciórese de que el número de serie y la fecha de compra del aparato están al alcance de la mano, si debe devolver la máquina al proveedor. Los daños de transporte que resulten de un embalaje defectuoso no están cubiertos por esta garantía.

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CHECK THAT :

The tension of your machine corresponds with the tension of your electrical network.

The machine's supply needs to be placed at disposal of a stand base of a compatible electric socket **CEI 60309-1**.

The supply connections must be congruent with the installation rules of the standard **NFC 15 100**.

INSTALL THE SIROCCO ON A STABLE WORKING BASE, CLOSE TO AN EASILY ACCESSIBLE ELECTRIC SOCKET.

Do not touch the socket with damp hands.

To unplug the machine, disconnect the plug without pulling on the supply lead.

To prevent electric shocks, do not use this laminating machine close to water.

Make a working area behind the machine.

Do not spill water on the machine, the supply lead or the electric socket.

Do not use the machine if the supply lead is damaged.

Do not leave the electric lead in contact with a warm surface.

The machine should be installed in a well-ventilated place.

The longitudinal knifes should not be used with documents which are not laminated paper (rigid support...).

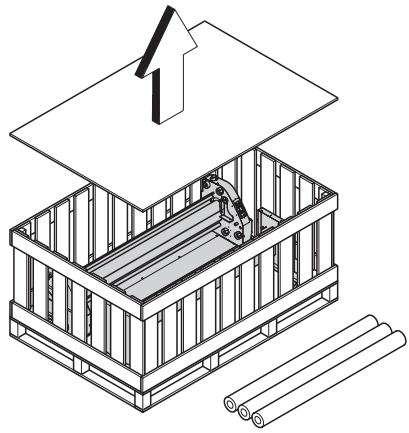
Disconnect the general supply of the machine with the switch (**item 21**) after each use.

During the assembly of the machine, be careful with the quartz heater and the ground areas (vibrations). If the machine must be disassembled, call a technician.

1 THE RECEPTION OF YOUR SIROCCO

1-1 The choice of the working space

Before unpacking your machine, it is necessary to determine your working area. You should have an easy access to all the parts of the machine.



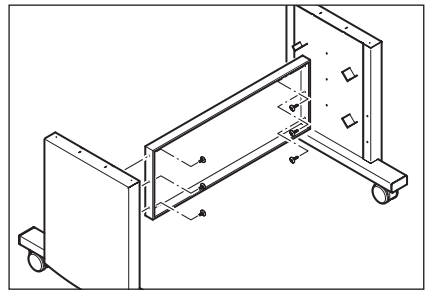
1-2 The unpacking of your machine

Take off the upper part of the packing case.
Remove the axles and the accessories included in the packaging.

1-3 The assembly of the support unit

Take out the parts which should include :
- 2 sides
- 1 panel
- 10 screws
- One 10 mm flat spanner

The assembly is done like this.

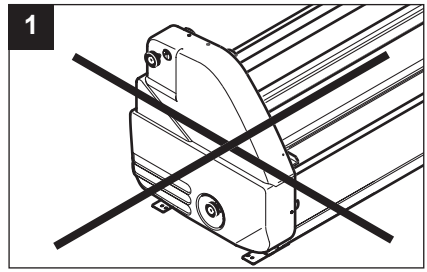


1-4 The positioning of the laminator on the support unit

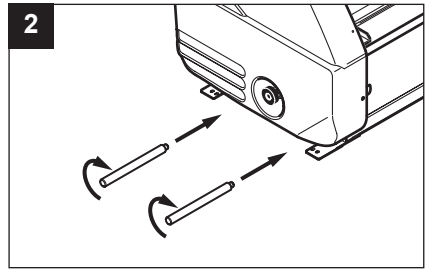
⚠ The machine is heavy. A minimum of **4** people is required for this operation.

⚠ Do not hold the machine by the lateral cover guards.

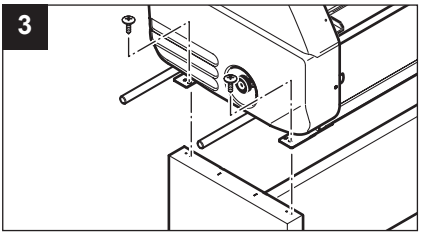
⚠ Hold the machine by its carrying handles.



• Place the machine on the support unit.



• Fix the assembly with the screws supplied with the support.



1-5 Start up kit (S.1600 only)

In the packing, you will find a complete start up kit containing :

- Two rollers of thermal film
- One roller of assembly film (double-sided)
- One roller of cold adhesive film
- Two chucks in cardboard

2 PROGRAMMING OF THE SPEED AND THE TEMPERATURE OF THE ROLLERS

The programs M1, M2, M3 and M4 can be selected by the operator.

To activate a program, Press MODE or M (**c**) buttons continually until the light corresponding to the required program comes on.

When a cold lamination, (the button ❄ (**f**) lights on the Sirocco 1080 and 1600), only the speed can be programmed.

2-1 Automatic stand-by

The light ⏻ (**e**) indicates that the machine has been automatically switched to stand-by after 30 mn of non-use.

The stand-by temperature can be set in the range 40-80°C.

⚠

For security reasons, the transition from cold to hot mode desactivates the heating rollers. Before hot lamination, it is necessary to start them up again by pressing ÷ (**o**).

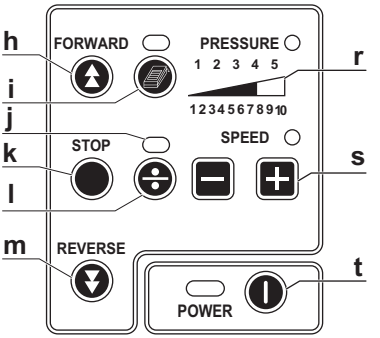
2-2 Programming of the speed

Sirocco 1080, 1600

To set up the speed, the light (**j**) must be off. If not, press ÷ (**l**).

Adjust the speed of the rollers by pressing the + and − keys (**s**) of the control panel.

The last value entered automatically replaces the previous stored value.



2-3 Programming of the temperature

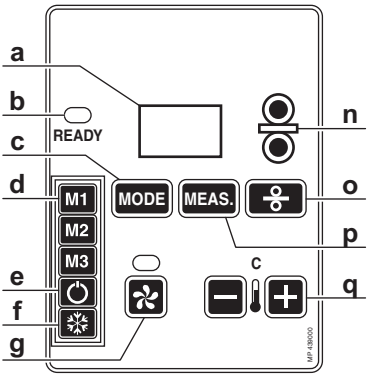
Sirocco 1080, 1600

Adjust the temperature of the rollers by pressing the keys (**q**) of the control panel.

Start the roller heating by pressing (**o**) and it is indicated by the light (**n**).

To know the temperature of a roller, press the button MEAS. (**p**).

If the light **(b)** is on, the required temperature is obtained (ready).



The last value entered replaces automatically the previous stored value.

3 ADJUSTMENT OF THE ROLLERS PRESSURE

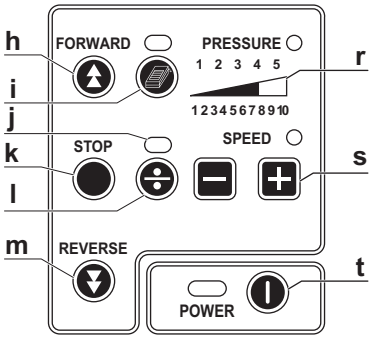
The Sirocco is fitted with a device for adjusting the space and the roller pressure. This device permits to laminate thick supports (Maximal thickness : 25 mm).

Sirocco 1080, 1600

Adjustment of the space between the rollers :

1- Press (**l**) if the light (**j**) and the light "PRESSURE" are not lighted ; the function is activated.

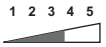
2- Press (**h**) until the required space is obtained.



Adjustment of the pressure of the rollers :

1- Press (**l**) if the light (**j**) and the light "PRESSURE" are not lighted ; the function is activated.

2- Press (**m**) continuously until display on control panel indicates the required pressure (**r**) :



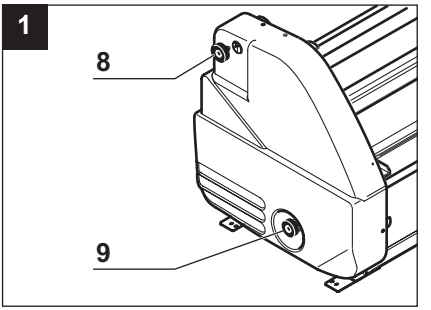
4 ADJUSTMENT OF THE FILMS TENSION

The handles (**Items 8 and 9**) are used to adjust the tension of the films on the self-locking axles.

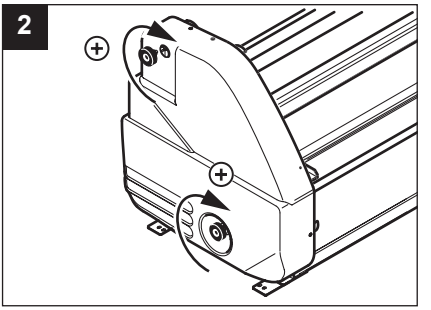
During the lamination, the film should be sufficiently tight to ensure a perfect lamination. However, the film should not be stretched excessively. Only by testing can you find the suitable tension. If some folds appear at level of the rollers, increase lightly the tension of the film.

To increase the tension of the film, turn the handles (**Item 8 or 9**) clockwise.

1



2



5 HOT LAMINATION

5-1 Feeding of the film Sirocco 1600

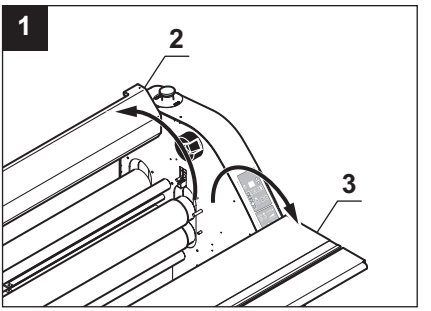
Turn on the machine with the switch located at the back of the machine (**Item 21**).The control panel lights.

Press ⏻ (**t**).

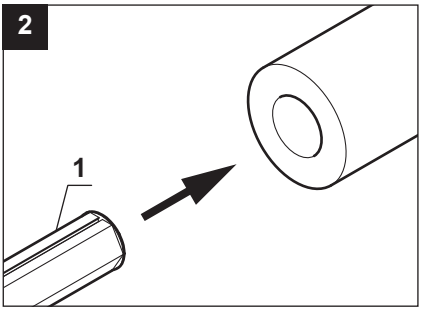
Adjust the temperature of the lamination (see chapter 3).

Remove the safety cover (**Item 2**) and the working table (**Item 3**).

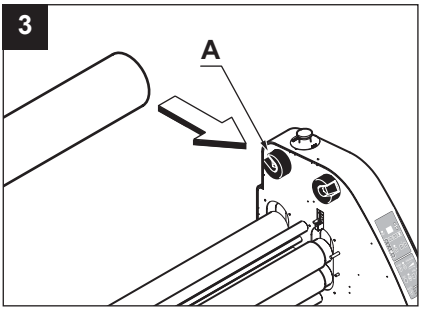
1



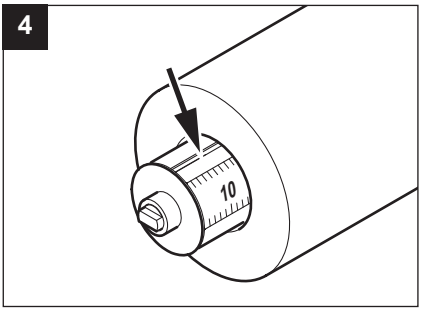
Introduce a self-locking axle (**Item 1**) inside the mandrel of the film reel.



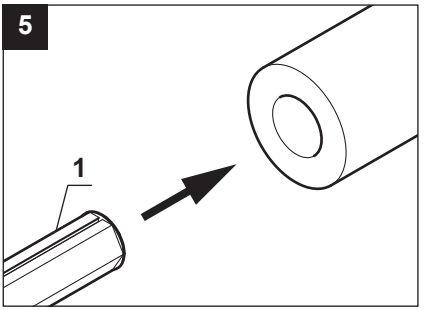
Place the assembly on the position (**A**) of the machine.



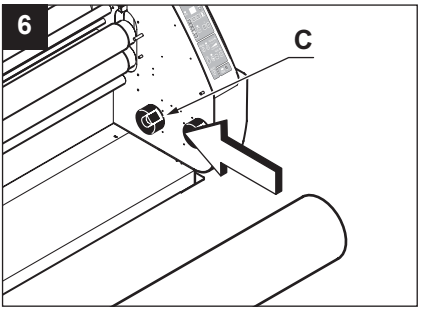
Centre the reel with the rules marked on the axle.



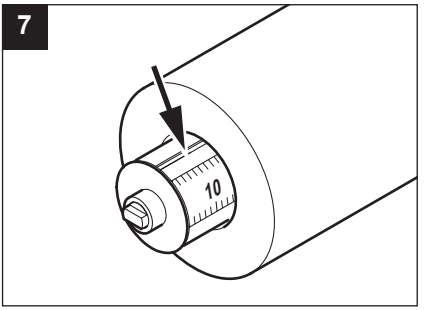
Introduce a self-locking axle (**Item 1**) inside the mandrel of the film reel.



Place the assembly on the position (**C**) of the machine.

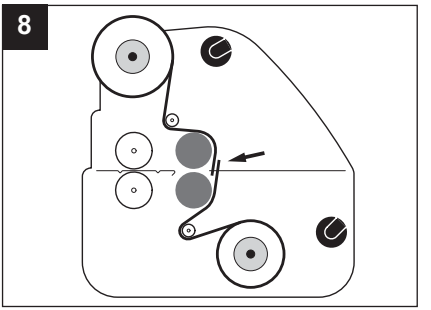


Centre the reel with the rules marked on the axle.



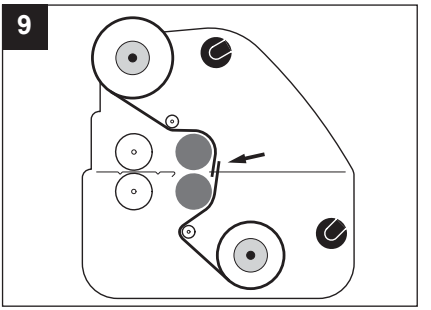
Place the film of the upper roller on the heating rollers (*adhesive side facing towards you*) by passing besides of the lower tension bar.

Place the film of the lower roller on the upper film (*adhesive side facing towards you*) by passing besides of the lower tension bar.



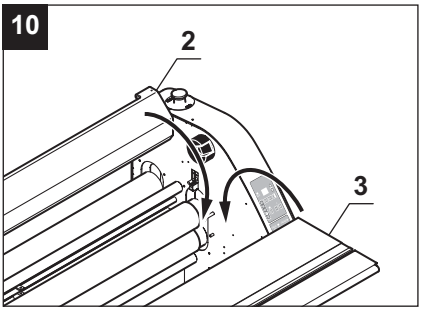
Respect the direction of the film according to its size :

- ***Diagram 8 :*** The adhesive is outside the rollers.
- ***Diagram 9 :*** The adhesive is inside the rollers.



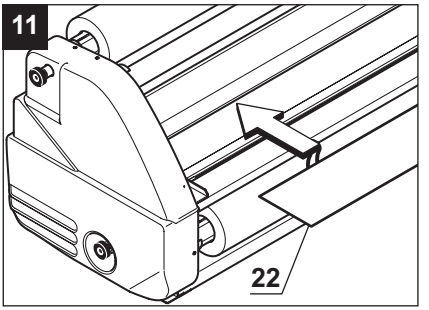
⚠ The temperature of the rollers must be sufficiently important to stick the films.

Place the safety cover (**Item 2**) and the working table (**Item 3**).



To operate the machine, the working table and the safety cover must be in place on the machine.

Insert the feeding plate (**Item 22**) between the rollers.



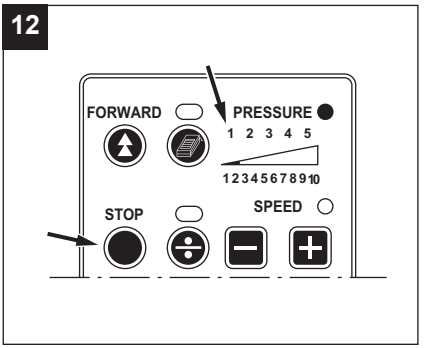
Adjust the rollers on the pressure position **1** (see chapter 3).

Press (**h**),"speed" mode and guide the feeding plate through until it comes out on the other side.

Press stop (**k**).

Cut the film with a safety cutter and recover the feeding plate.

Adjust the pressure of the rollers according to the application (see chapter 3).

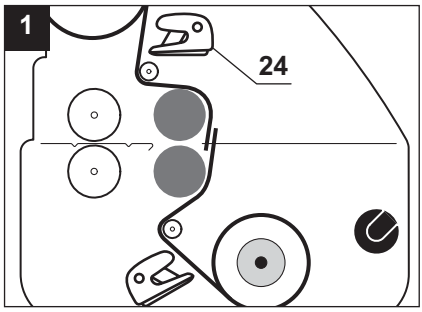


Remove pressure from the rollers before switching the machine off.

5-2 Changing of the film rollers

Stop the machine by pressing the button stop ◉ or ◉ (**k**).

Cut the films of the reels with a safety cutter (**Item 24**).

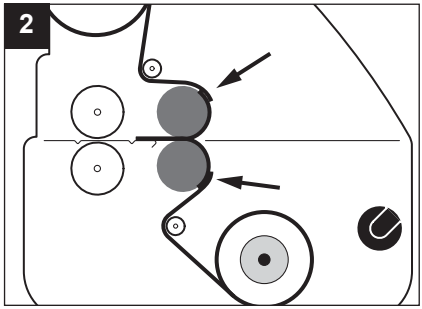


⚠ Not to damage the heating rollers during this operation.

Remove the worned reels and replace them with the new ones.

Place the new films in such a way that its extremities stick to the old films in contact with the heating rollers.

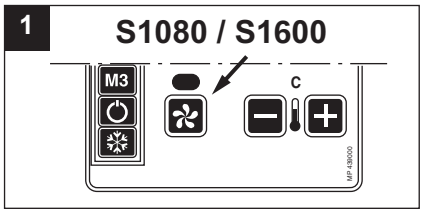
Press ◉ (**h**).



5-3 Use of the ventilators

The ventilators are recommended for cooling the films during the lamination of the documents with thick films.

The ventilators are started or stopped by pressing the key ◉ (**g**).



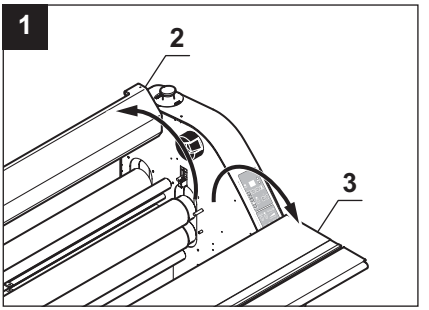
6 COLD LAMINATION

6-1 Lamination on one side

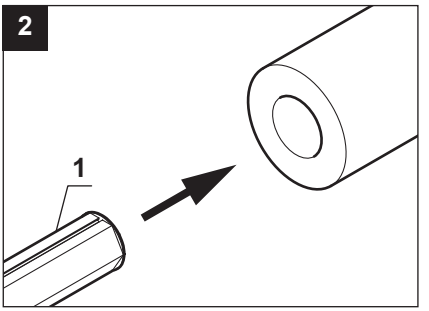
Turn on the machine with the switch located at the back of the machine (**Item 21**). The control panel lights.

Press ⏻ (**t**).

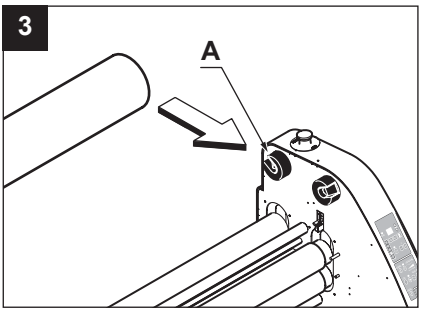
Remove the safety cover (**Item 2**) and the working table (**Item 3**).



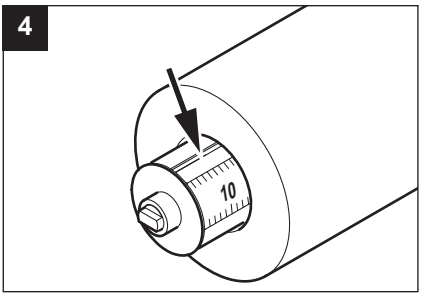
Introduce a self-locking axle (**Item 1**) inside the mandrel of the film reel.



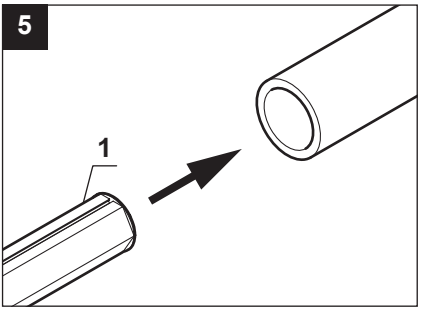
Place the assembly on the position (**A**) of the machine (The film base paper towards the top).



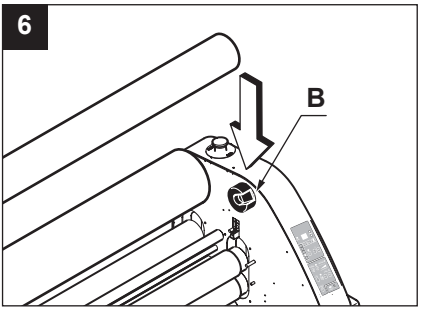
Centre the reel with the rules marked on the axle.



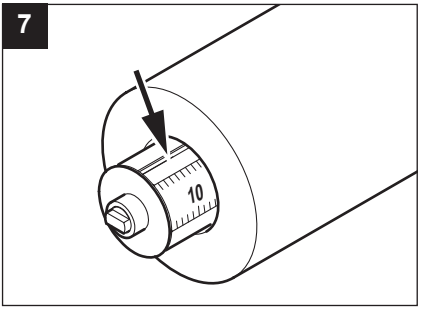
Introduce a self-locking axle (**Item 1**) inside the cardboard tube used to recover the film base paper.



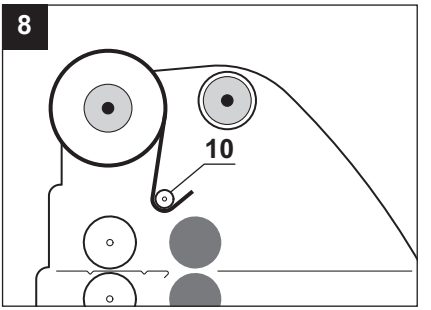
Place the assembly on the position (**B**) of the machine.



Centre the reel with the rules marked on the axle.

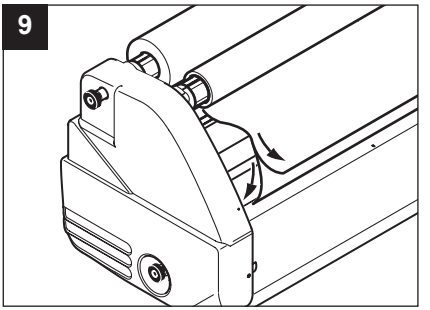


Pass the film and its base paper behind the upper tension bar (**Item 10**).



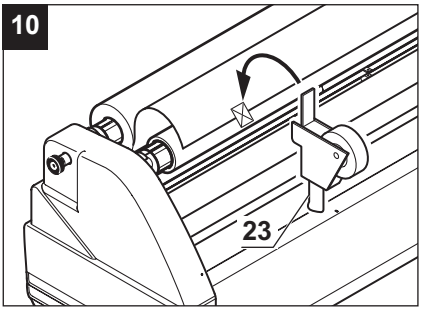
Separate the film from its base paper.

9



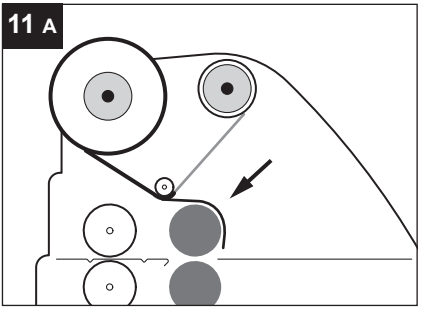
Stick the protective paper on the cardboard tube with the reel pistol (**Item 23**).

10

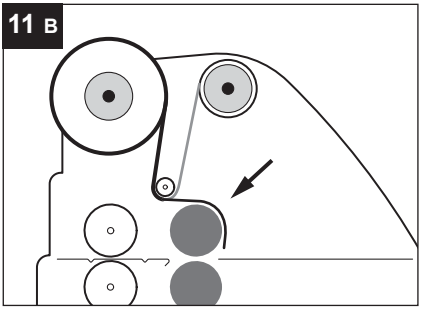


Place the film on the upper laminator reel (adhesive side facing towards you).

11 A



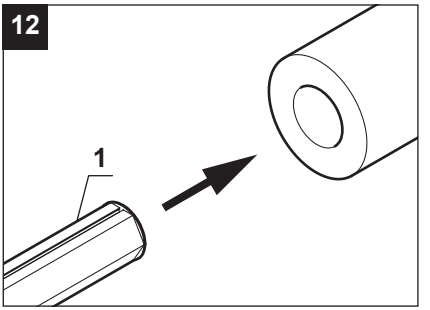
11 B



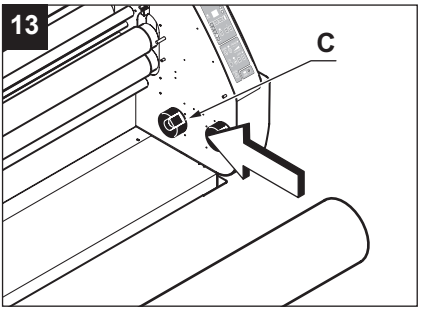
Introduce a self-locking axle (**Item 1**) inside the mandrel of the paper reel (not supplied in the start-up kit).

The paper reel should be wider than the film reel.

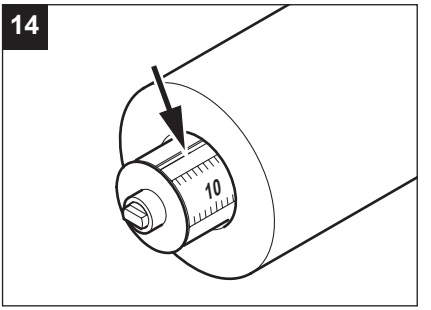
12



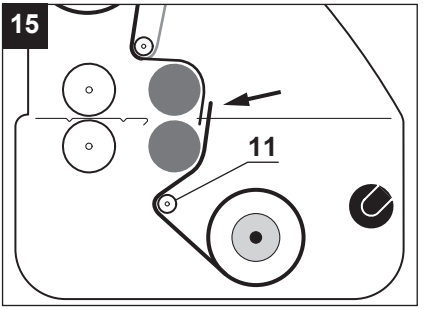
Place the assembly on the position (**C**) of the machine.



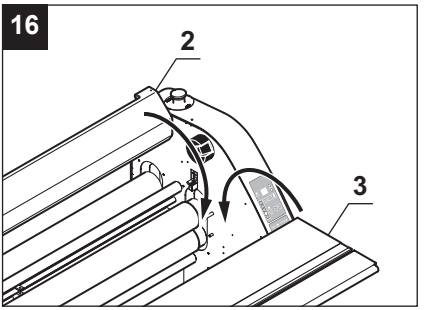
Centre the reel with the rules marked on the axle.



Stick the paper on the adhesive film by passing under the lower tension bar (**Item 11**).

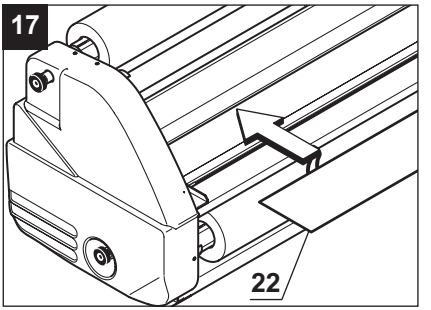


Place the safety cover (**Rep.2**) and the working table (**Item 3).**
S1600 : Reinitialize the machine with the pushbutton, located under the table, on the right.



⚠ To operate the laminating machine, the working table and the safety cover should be placed on the machine.

Insert the feeding plate (**Item 22**) between the rollers.



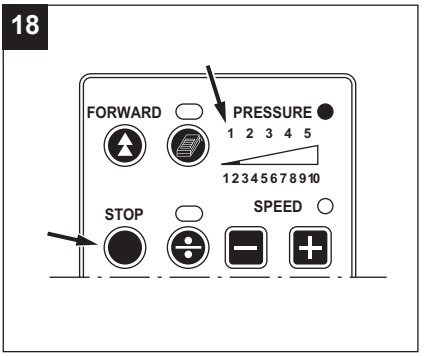
Adjust the rollers on the pressure position **1** (see chapter 3).

Press ⏫ in “speed” mode and guide the plate through until it comes out on the other side.

Press the button stop ⏺ (**k**).

Cut the film with the safety cutter and recover the feeding plate.

Adjust the pressure of the rollers according to the application (see chapter 3).

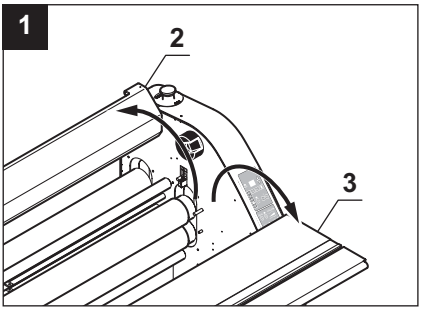


6-2 Lamination on one side and simultaneous application of adhesive

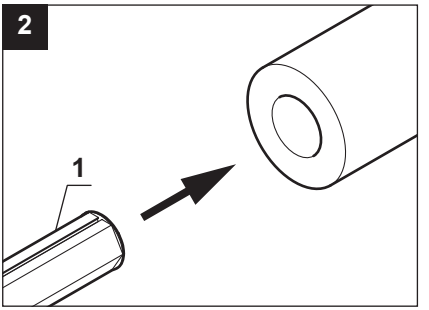
Power up the machine with the switch located at rear of the machine (**Item 21**). The control panel lights.

Press ⏻ (**t**).

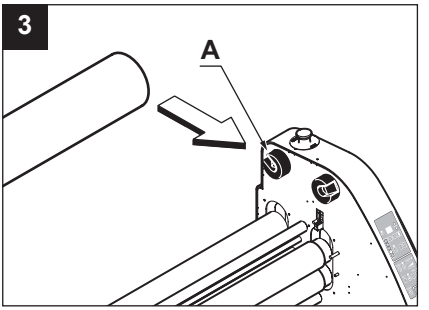
Remove the safety cover (**Item 2**) and the working table (**Item 3**).



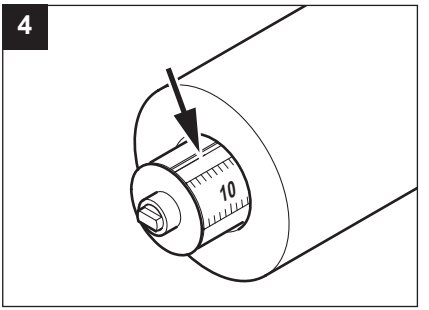
Introduce a self-locking axle (**Item 1**) inside the mandrel of the film reel.



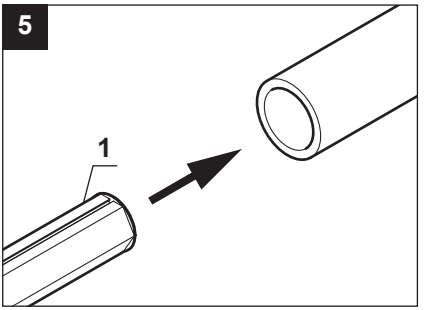
Place the assembly on the position (**A**) of the machine (*base paper of film towards the top*).



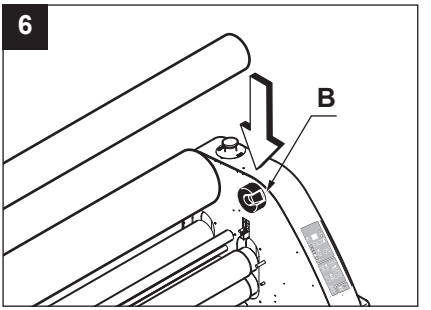
Centre the reel with the rules marked on the axle.



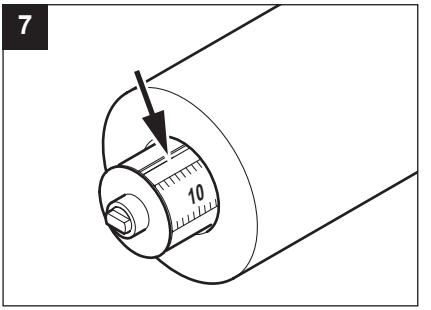
Introduce a self-locking axle (**Item 1**) inside the cardboard tube used to recover the film base paper.



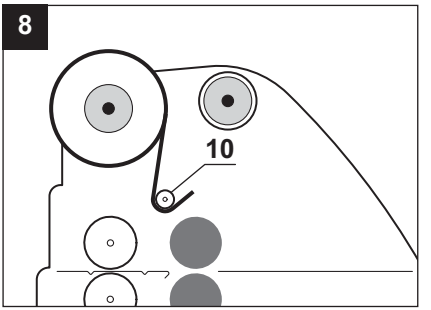
Place the assembly on the position (**B**) of the machine.



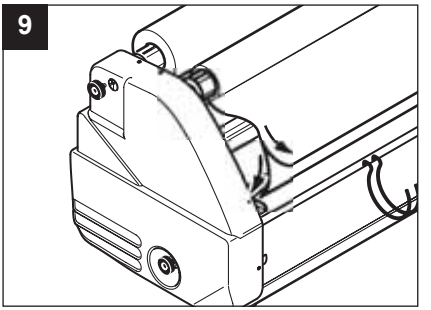
Centre the reel with the rules marked on the axle.



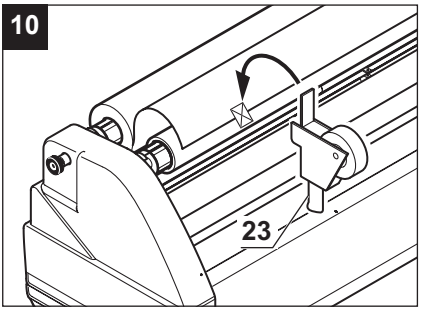
Pass the film and its base paper behind the upper tension bar **(Item 10**).



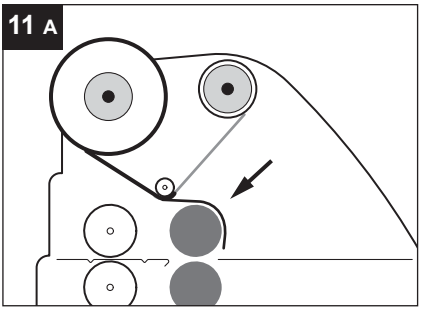
Separate the film from its base paper.

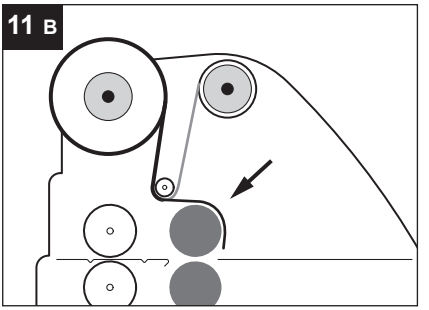


Stick the base paper on the cardboard tube with the reel pistol (**Item 23**).



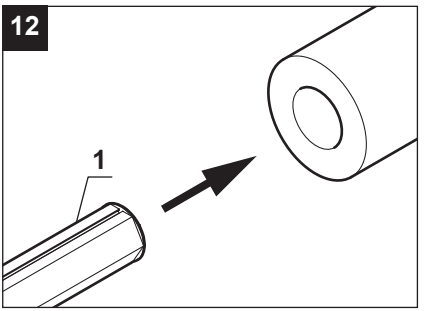
Place the film on the upper laminator roller (adhesive side facing towards you).





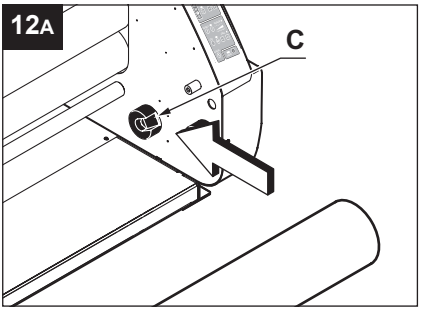
For the reel of adhesive film without protective paper :

- Introduce a self-locking axle (**Item 1**) inside the mandrel of the film reel.

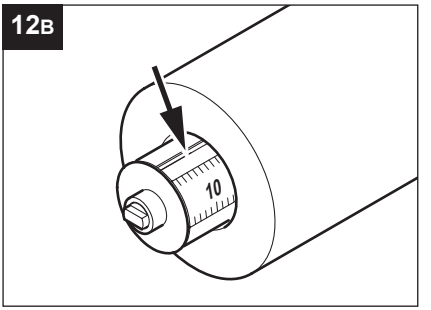


- Place the assembly on the position (**C**) of the machine.

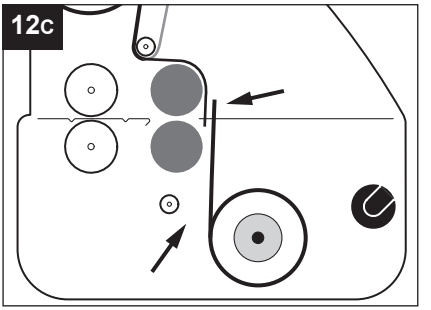
- Lock the lower axle with the blocking ring (see chapters n°6-5-A).



- Centre the reel with the rules marked on the axle.



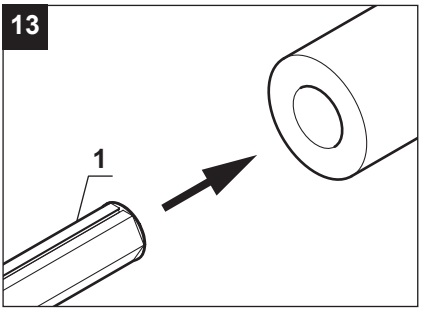
- Stick the lower adhesive film on the upper film by passing in front of the lower tension bar.



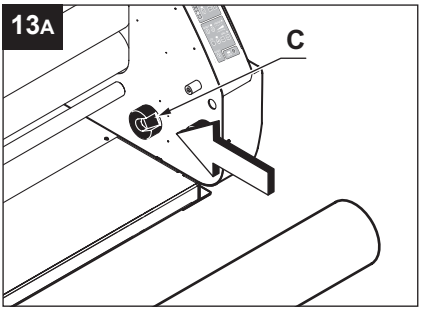
⚠ The double-sided film should be placed in front of the tension bar.

For the reel of adhesive film with protective paper :

- Introduce a self-locking axle (**Item 1**) inside the mandrel of the film reel.

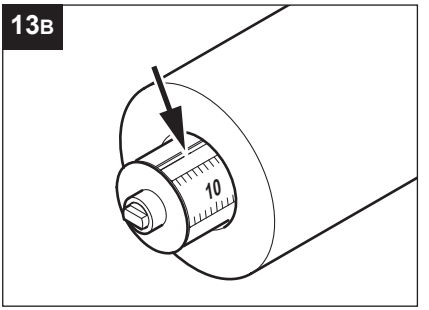


- Place the assembly on the position (**C**) of the machine.



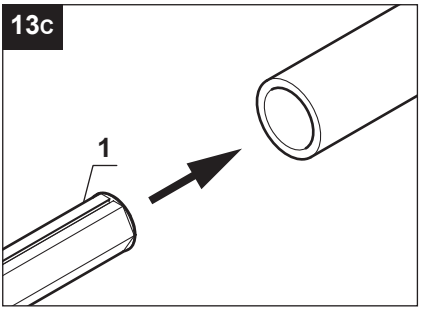
- Centre the reel with the rules marked on the axle.

13B



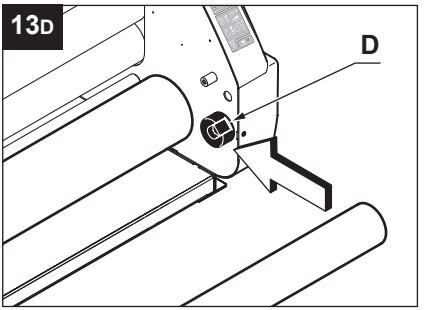
- Introduce a self-locking axle (**Item 1**) inside the cardboard tube to reco ver the base paper of film.

13C



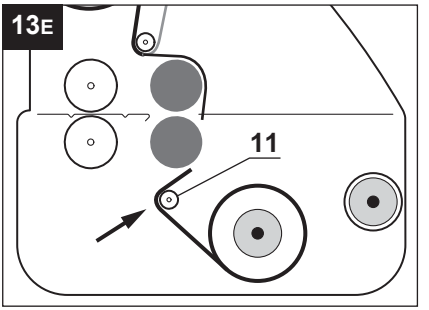
- Place the assembly on the position (**D**) of the machine.

13D



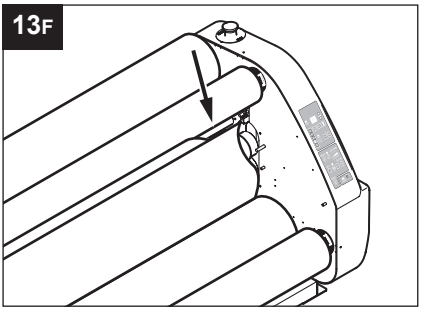
- Pass the film and its base paper under the lower tension bar (**Item 11**).

13E



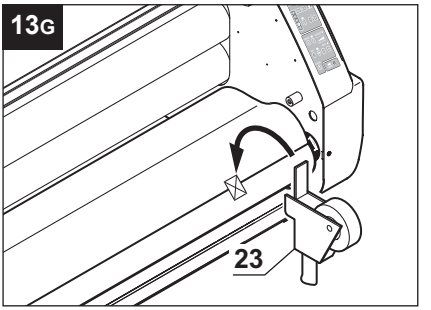
- Separate the film from its base paper.

13F



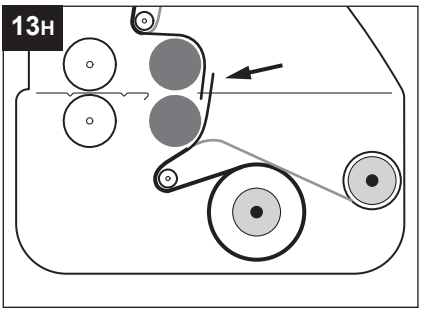
- Stick the base paper on the cardboard tube with the reel pistol (**Item 23**).

13G

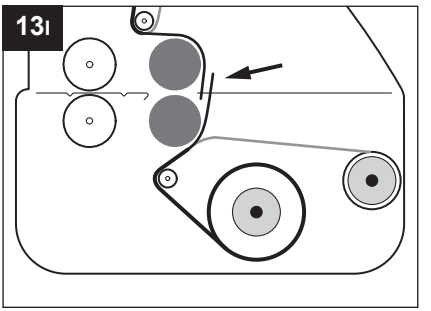


Stick the lower adhesive film on the upper adhesive film by passing under the lower tension bar.

13H

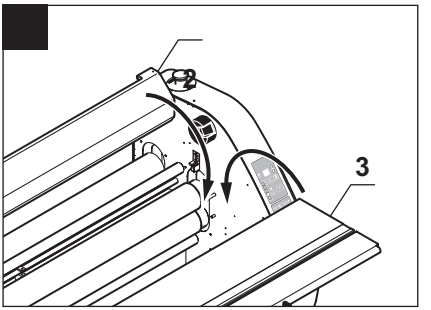


13I



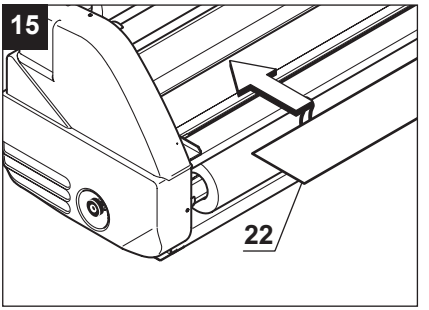
Place the safety cover (**Item 2**) and the working table (**Item 3).**

S1600 : Reinitialize the machine with the pushbutton, located under the table, on the right.).



⚠ To operate the machine, the working table and the safety cover should be placed on the machine.

Insert the feeding plate (**Item 22**) between the rollers.



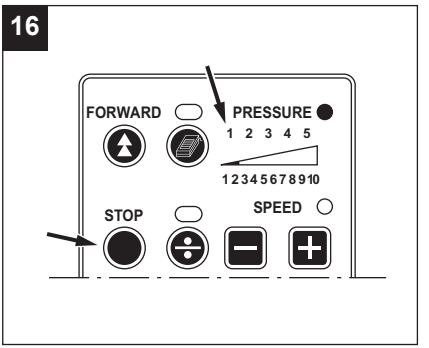
Adjust the rollers on the pressure position **1** (see chapter 3).

Press (**h**) in “speed” mode and guide the plate through until it comes out on the other side.

Press the button stop (**k**).

Cut the film with the safety cutter and recover the feed plate.

Adjust the pressure of the rollers according to the application (see chapter 3).

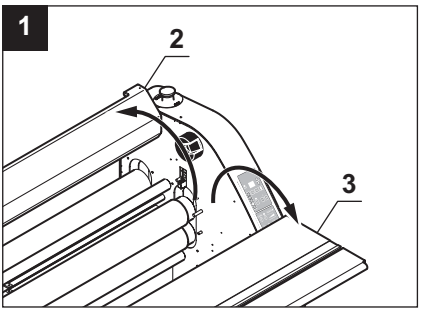


6-3 Two sides lamination (S.1600 only)

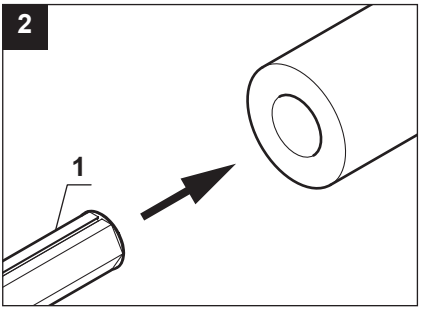
Turn on the machine with the switch, located at rear of the machine (**Item 21**). The control panel lights.

Press (**t**).

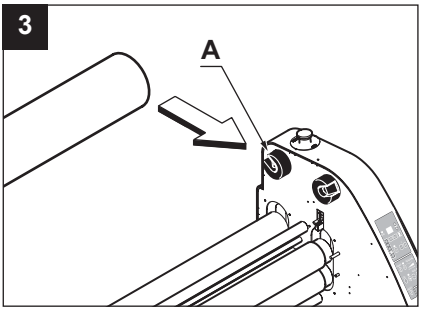
Lift the safety cover (**Item 2**) and the working table (**Item 3**).



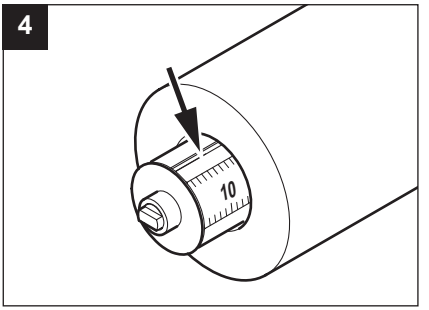
Introduce a self-locking axle (**Item 1**) inside the mandrel of the film reel.



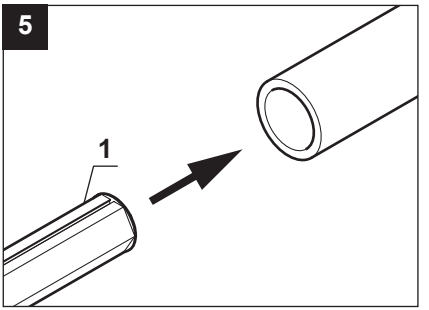
Place the assembly on the position (**A**) of the machine (*base paper of film towards the top*).



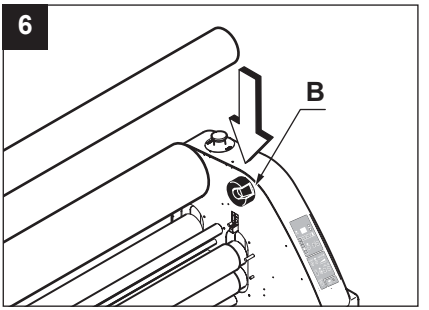
Centre the reel with the rules marked on the axle.



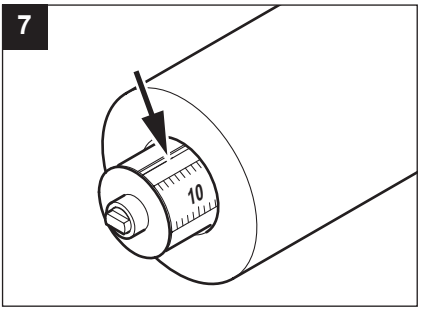
Introduce a self-locking axle (**Item 1**) inside the cardboard tube to recover the base paper of film.



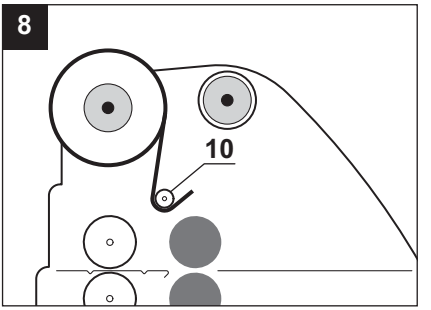
Place the assembly on the position (**B**) of the machine.



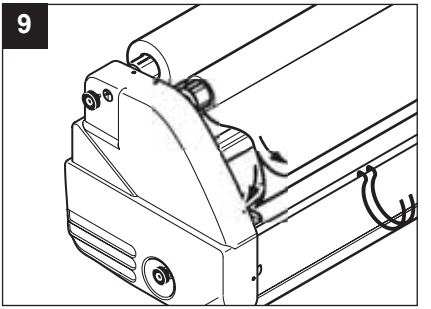
Centre the reel with the rules marked on the axle.



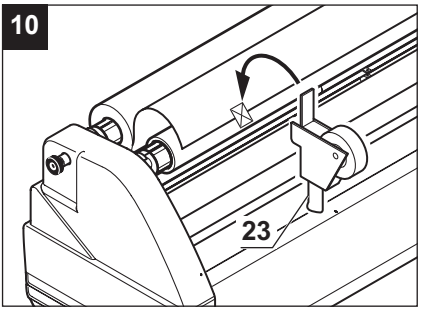
Pass the film and its base paper behind the lower tension bar (**Item 10**).



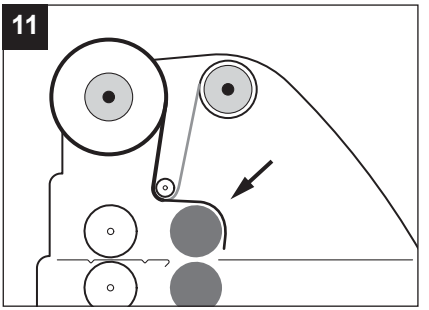
Separate the film from its base paper.



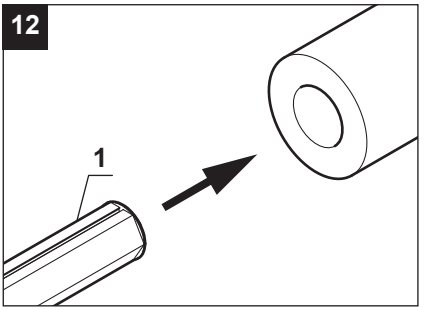
Stick the base paper on the cardboard tube with the reel pistol (**Item 23**).



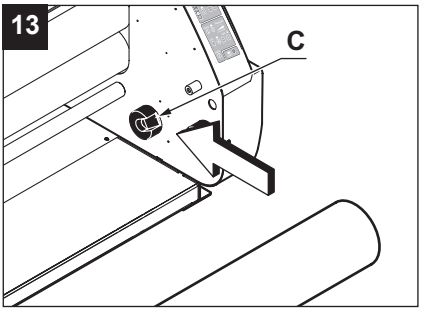
Place the film on the upper laminating roller (adhesive side facing towards you).



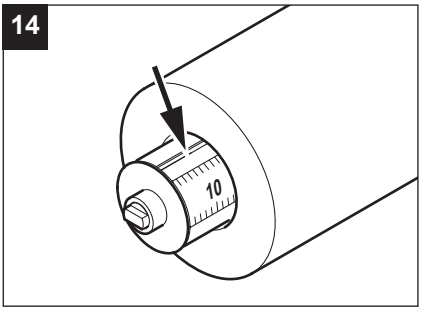
Introduce a self-locking axle (**Item 1**) inside the mandrel of the film reel.



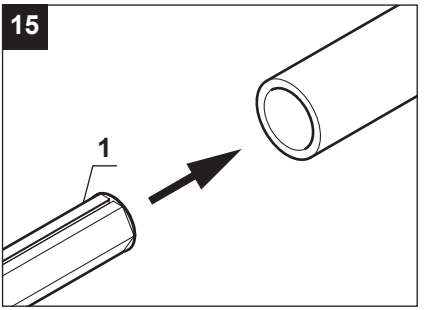
Place the assembly on the position (**C**) of the machine.



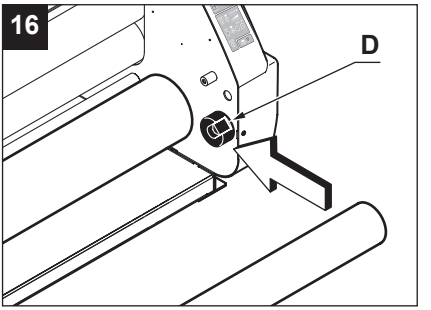
Centre the reel with the rules marked on the axle.



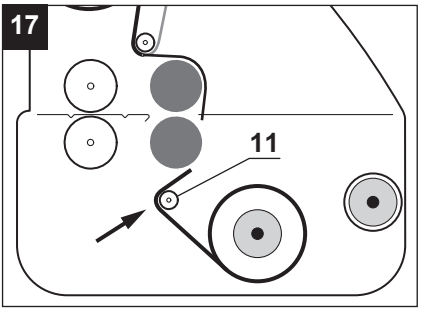
Introduce a self-locking axle (**Item 1**) inside the cardboard tube to recover the base paper of film.



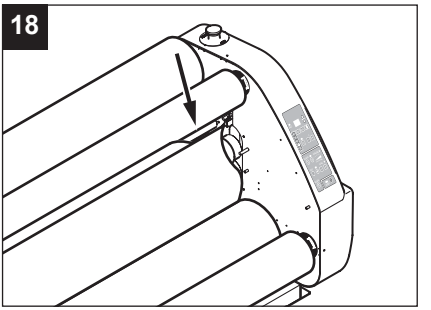
Place the assembly on the position (**D**) of the machine.
(**D**) is not part of S.1080



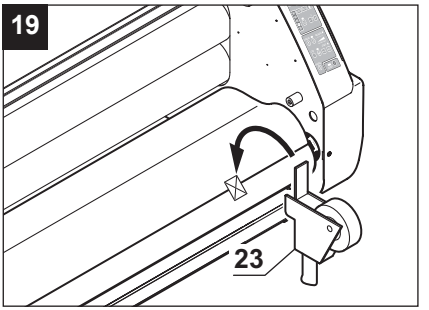
Pass the film and its base paper under the lower tension bar (**Item 11**).



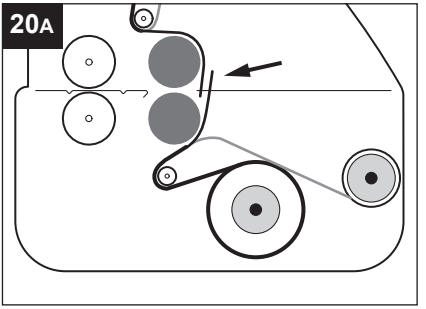
Separate the film from its base paper.

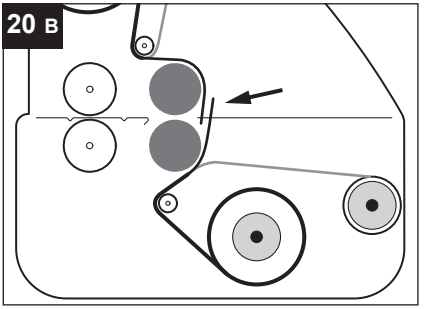


Stick the base paper on the cardboard tube with the reel pistol (**Item 23**).



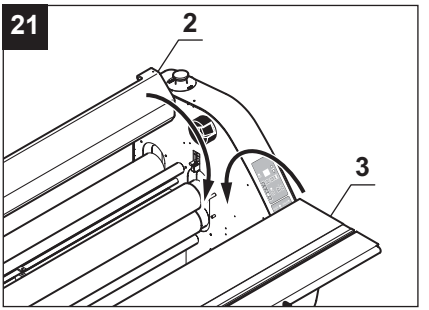
Stick the lower adhesive film on the upper adhesive film by passing under the lower tension bar.





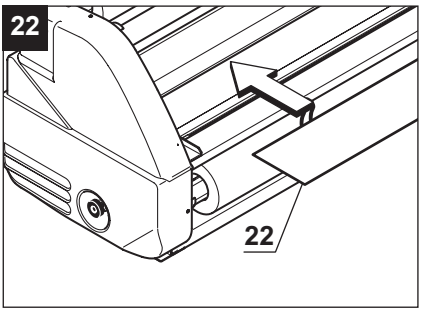
Place the safety cover (**Item 2**) and the working table (**Item 3**)

S1600 : Reinitialize the machine with the pushbutton, located under the table, on the right..



⚠ To operate the machine, the working table and the safety cover should be placed on the machine.

Insert the feeding plate (**Item 22**) between the rollers.



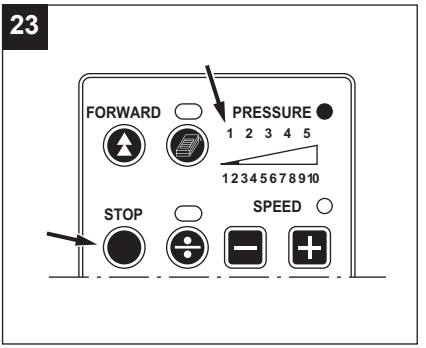
Adjust the rollers on the pressure position **1** (see chapter 3).

Press (**h**) in “speed” mode and guide the feeding plate through until it comes out on the other side.

Press stop (**k**).

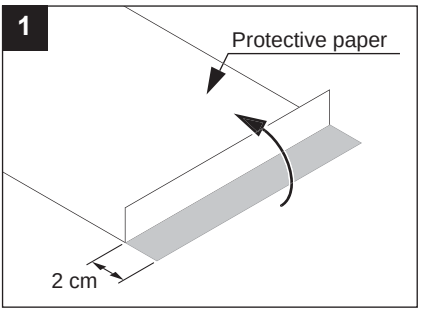
Cut the film with a safety cutter and recover the feeding plate.

Adjust the pressure of the rollers according to the application (see chapter 3).

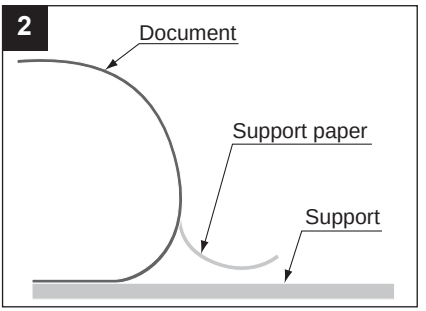


6-4 Mounting and sticking on an adhesive support

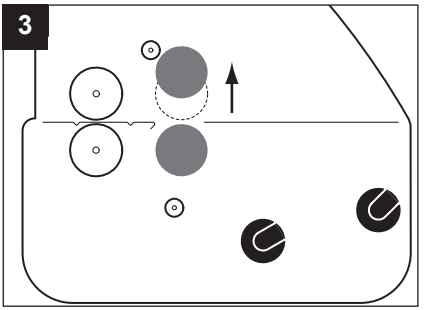
On the adhesive document, peel back a strip of protective paper from the film about 2 cm, and fold back.



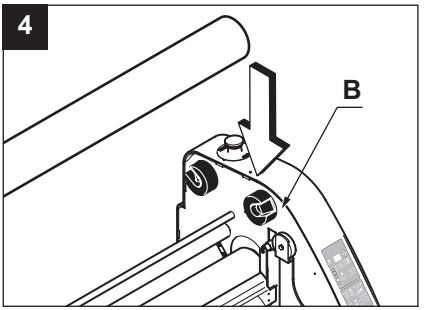
Place the document and stick it on the support.



Set the rollers at maximum separation (see chapter 3).

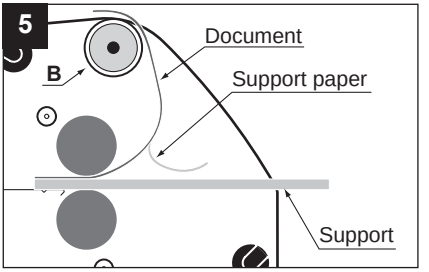


Place a mandrel with a cardboard tube on the position (**B**).



Shows the assembly for adhesive application on the working table between the rollers.

Place the document to be mounted on the cardboard tube in position (**B**).

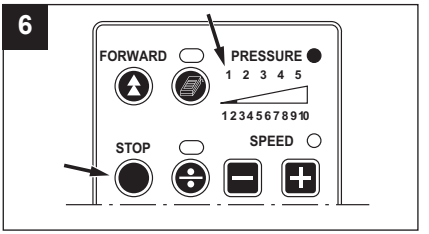


Adjust the rollers on the pressure position **1** (see chapter 3).

For the Sirocco 1080, 1600 :

Press (**c**) in “speed” mode and guide the plate through until it comes out on the other side.

Peel back the protective paper progressively as it advances towards the laminator rollers, by guiding manually.

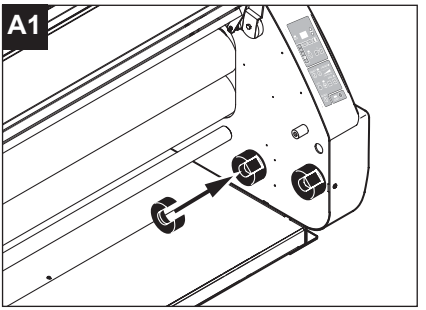


6-5 Simplification of utilization

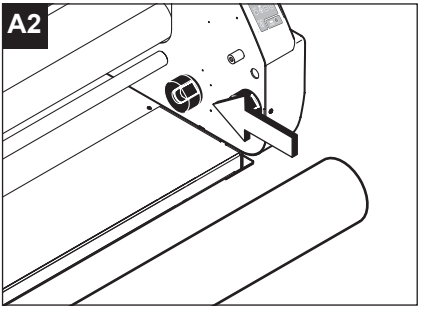
A - Blocking ring :

It allows to avoid the shrinking of the lower self-locking axle during a lamination on one side or/and a simultaneous adhesive application. It places on the bearing of the lower axle.

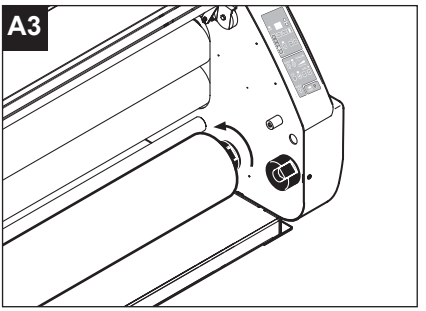
Place the ring on the bearing.



Place the self-locking axle on position.



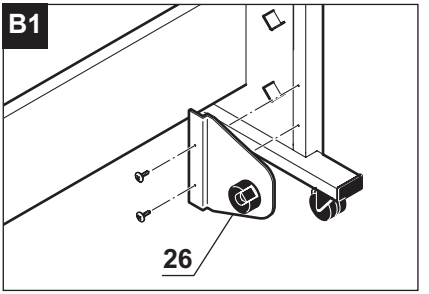
Turn the ring a quarter towards the top.



B - Rewinder (optional) :

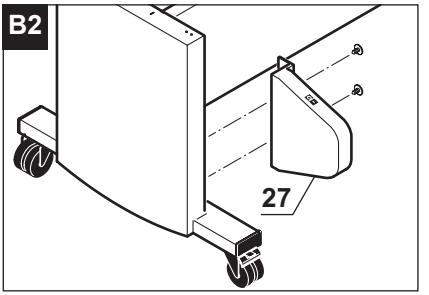
A winder axle permits to wind on the laminated support in machine exit. This axle is in position.

Put the plate (**Item 26**), on the right side with the screws supplied.

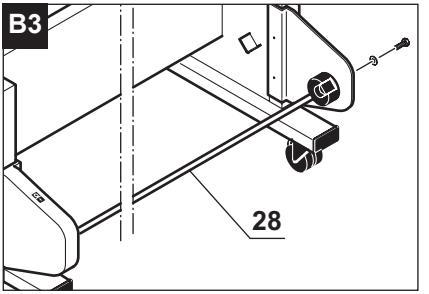


Put the plate (**Item 27**), on the left side with the screws supplied.

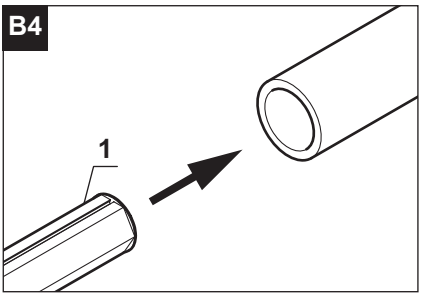
Connect the supply to the winder.



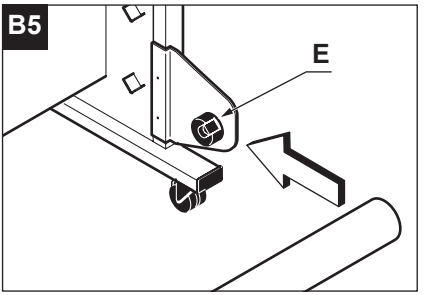
Place the reinforcing bar (**Item 28**) with the screws supplied.



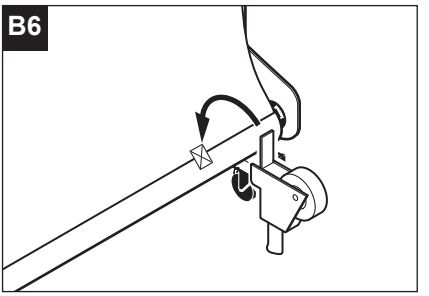
Introduce a self-locking axle (**Item 1**) inside the cardboard mandrel.



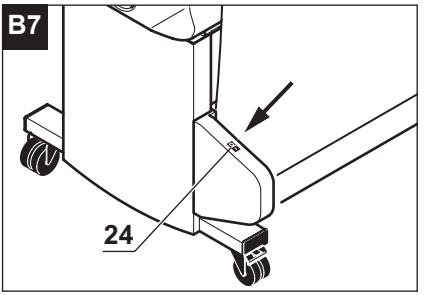
Place the assembly on the position (**E**) of the machine.



Stick the plastified document on the cardboard tube in order to start the reeling.



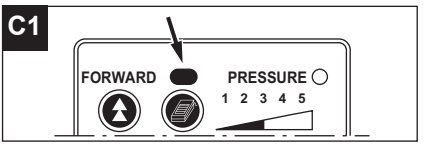
Power up the winder with the button (**Item 24**).



C - Use of the pedal control :

Advance the key (**d**).

Press the pedal in order to start the rollers. Your hands are free to guide the document to laminate.



7 ADJUSTMENT

Cold lamination

NB : For cold lamination, it is possible to heat the rollers to 50°C to accelerate the polymerization of the adhesive.

	Lamination on one side			Lamination both sides	
	Paper	Polyester	Vinyl	Paper	Polyester
Speed	3 to 5	3 to 5	3 to 5	3 to 5	3 to 5
Pressure	4 to 5	4 to 5	2 to 3	4 to 5	4 to 5

	Adhesive application on support		Mounting, Sticking	
	Paper	Polyester	Foam	PVC
Speed	3 to 6	3 to 6	4 to 7	4 to 7
Pressure	4 to 5	4 to 5	1 to 2	2 to 3

Lamination / Hot encapsulation
(values given for information only).

	Offset Document			Inkjet Document		
Films (µm)	T° C	Speed	Pressure	T° C	Speed	Pressure
42	110/120	1/3	3/5	90/100	1/3	3/5
75	110/120	1/3	3/5	90/100	1/3	2/5
125	115/125	1/3	3/5	90/100	1/3	2/5
250	120/130	1/2	3/5	90/100	1/2	2/5

8 TECHNICAL CHARACTERISTICS

8-1 SIROCCO 1080

Maximum working width (in mm)	1080
Maximum space between rollers (in mm)	25
Roller pressure (in daN)	15 à 70
Maximum speed (M/minute)	3
Dimension L x H x P (in cm)	142x58x62
Dimension L x H x P (in cm with stand)	142x126x76
Weight, stand weight (in Kg)	122 - 42
Minimum and maximum temperature (°C)	40 - 160
Heating power (in watt)	2800
Motor power (in watt)	100
Voltage	230V-240V 50Hz/60Hz
	single phase
Intensity (A)	13
Heat up time (in minutes)	15

8-2 SIROCCO 1600

Maximum working width (in mm)	1600
Maximum space between rollers (in mm)	25
Roller pressure (in daN)	15 à 70
Maximum speed (M/minute)	3
Dimension L x H x P (in cm)	194x137x76
Weight (in Kg)	287
Minimum and maximum temperature (°C)	40 - 160
Heating power (in watt)	3400
Motor power (in watt)	100
Voltage	230V-240V 50Hz/60Hz
	single phase
Intensity (A)	16
Heat up time (in minutes)	30

9 MAINTENANCE AND SAFETY

9-1 Maintenance

FREQUENCY	TYPE OF COMPONENTS	ACTION
Immediately	Marks of ink on the rollers or on the table	Aqueous solvent
Weekly	Laminator rollers (*)	Aqueous solvent
	Heating rollers (*)	Aqueous solvent
	Working table	Aqueous solvent
	Rear table	Aqueous solvent
	Safety cover	Aqueous solvent
	Right or left cover guard	Aqueous solvent
Monthly	The support unit	Aqueous solvent
	Upper tension bar	Aqueous solvent
	Lower tension bar	Aqueous solvent

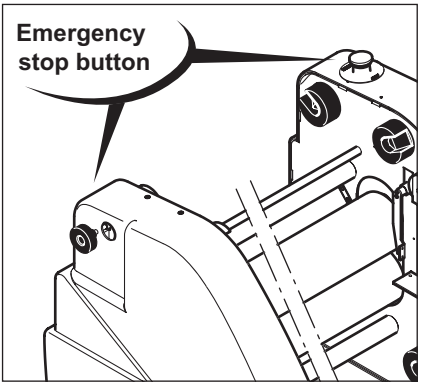
(*) : The cleaning is carried out with the rollers at maximum spacing, with power off and safety cover removed (the rollers should be at ambiant temperature).

NEVER LEAVE THE LAMINATOR ROLLERS UNDER PRESSURE DURING A LONG PERIODS STOPPED, RISK OF DEFORMATION OF THE SILICONE.

9-2 Safety : Weekly test

Emergency stop button :

- Put the rollers under pressure and then set them in motion.
- Press down an emergency stop button.
- The rollers come to a stop.
- Unlock the buttons (press up).
- Use same method for the second emergency stop button.



10 CONDITIONING OF FILM REEL

Long term :

The reels should be stored upright, in their original packing, in a room free from dust, and unaffected by variations in humidity and temperature.

Short term :

The reels can be left on the self-locking axle and placed on the supports of the support unit.

NEVER LAY THE FILM REELS ON THE FLOOR, RISK OF DEFORMATION.

11 INCIDENTS

PROBLEMS	POSSIBLE CAUSES	ACTION
The lamination of the document fails or is only partly successfull.	The temperature is too low.	Increase the temperature by 10°, wait 10 minutes and carry out another test.
	The document has a silicone laquer.	Check the document.
	Some film or adhesive sticks on the rollers.	Clean the rollers.
	The document is too humid.	

PROBLEMS	POSSIBLE CAUSES	ACTION
The document becomes warped or folded during the lamination.	The document fed in too rapidly. The document left too long next to heating for rollers. The document wasn't flat when loaded. The paper is too light or too humid.	a) Hold the document more firmly when feeding into machine. b) Lower the temperature slightly. c) Increase the speed of rollers. d) Use the ventilators.
There are lengthwise folds on the plastic film.	The tension of the film is too weak.	a) Tighten the reel chuck brake until folds disappear. b) Check loading of the rollers. c) Check there are not adhesive marks from the rollers.
Appearance of bubbles on the document.	The document is humid.	
Warping or moiré effect on surface.	The temperature is too high.	a) Reduce the temperature and/or increase the speed b) Use the ventilators.
Regular appearance of bubble or pockets.	Adhesive stuck on the rollers.	a) If the problem arises every 170 mm : check the heating rollers. b) If the problem arises every 125 mm : check the laminator rollers.

PROBLEMS	POSSIBLE CAUSES	ACTION
Darkened document	Evaporation of the solvent from ink on document	a) Laminate the dark area in last. b) Increase the speed and slide the document in the rollers, without holding back.
The document rolls up towards the top.	The tension is too high on the upper film.	The tension of the lower and upper films should be practically identical.
The document rolls up towards the bottom.	The tension is too high on the lower film.	The tension of the lower and upper films should be practically identical.

12 MAINTENANCE

The user maintenance is limited to the regular maintenance of the objects of the paragaph 11 and to the replacement of the power plug : in case of replacement use exclusively a **CEI 60309-1** model.
For all others defects, contact the installer approved by the manufacturer.

13 DISPOSAL

The Sirocco contains no components harmful to the environment. The disposal of your Sirocco must be collected by a recycling company.
The Sirocco is designed and constructed so that the noise emitted during operation is lower than 70 dB.

NOTE :